

Date: Monday, 10/16/2006 1:56:33 PM
User: Kim Johnston

Process Sheet

plut
SB 06/11/02

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 28996	
Estimate Number : 10200	
P.O. Number : N/A	Part Number : D21991
This Issue : 10/16/2006 S.O. No. : N/A	Drawing Number : D2199 REV. E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : E1
Previous Run : 28071	Material : N/A
Written By : <u>JA 061016</u>	Due Date : 10/30/2006
Checked & Approved By : <u>JA 061016</u>	Qty: 10 Um: 8 Each
Comment : Est B 02-06.10 Added finish NG/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.6275 f(s)/Unit Total: 9.7650 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M102502

FF 06-11-30 10

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC

Punch per Dwg. D2199 and Spec Control Dwg D2638

FF 06-11-30 10

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

JAN 06:11:30 (10)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

M 06/11/30 (10)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Q.M 06/12/01 (10X)

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

PB 06/12/04 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 28996

Part Number: D21991

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57221*

PB06/12/04 @

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
06/12/05

Job Completion



C Loc 12/05






W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

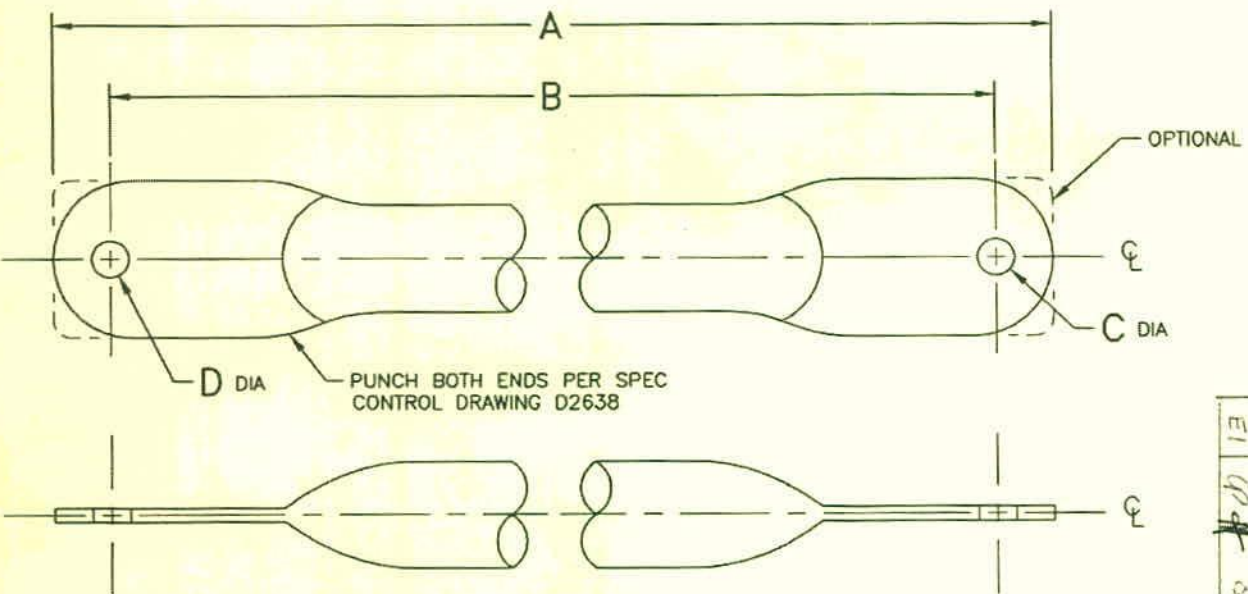
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. E
				D2199	SHEET 1 OF 1
DATE				TITLE	SCALE
98.04.28				STRUT DETAILS	NTS
A			1993	NEW ISSUE	
B				ADDED -11, -13, AND -15	
C				ADDED -17 AND -19	
D				ADDED -21	
E			98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
E1			02.03.22	ADD FINISH	

RELEASED
1980-05-05 KFE

98.05.05 KE



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B
B
B
C
C
D
E
E

00.10.13
ip 00.10.13

NOTES:

3. FINISH: POWDER COAT WHITE (4.3.5.2) PER PART QSI 005 4.3/EI

SHOP COPY
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ENGINEERING
IMC CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ORDER 4

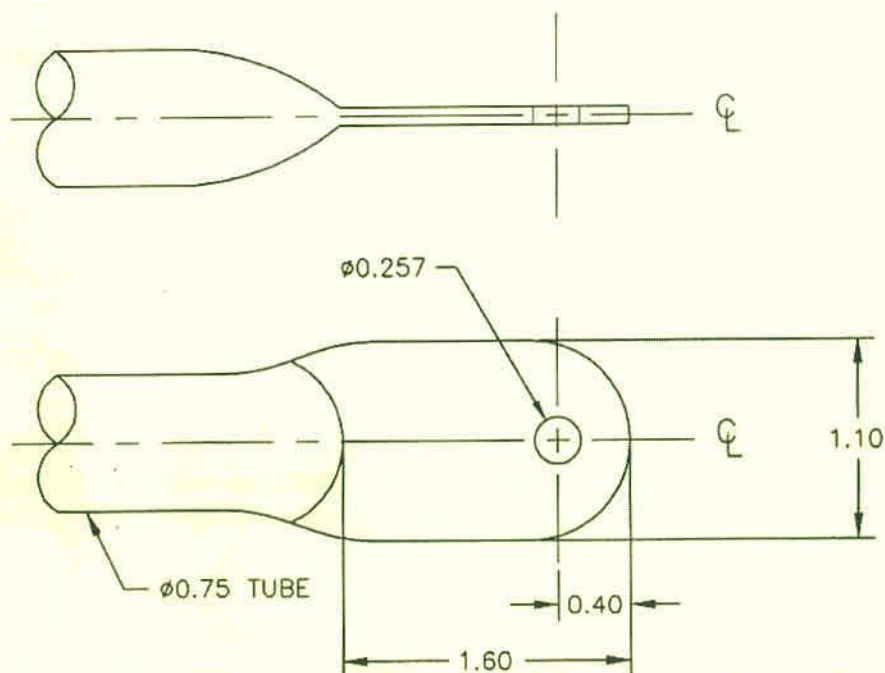
WORK ORDER
28996
NO



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DIB	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/09/09 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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WITHOUT NOTICE
WORK ORDER
NO. 28996

